



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

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D5467-1

Job Sheet 198587



Part No: D5467-1

Job Qty: 8 pcs

Part Name: Saddle, Fwd, Out



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 7/31/19

Job Tracking No:

Created By: Marie Lajeunesse

Due Date: 9/9/19

Description:

Type: Stock

Note: IPP Rev.A 17.07.12 New issue DP Verify DD IPP REV:B 17.11.03 AS PER DWG REV.A DD VERF:DP
Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard Setup Hrs	Run Hrs	Workcenter/Supplier	Sign-off
90	Machining - Issue SN	8 pcs	9/9/19	9/9/19	0.00	0.00	HAAS - 1	SBL 19/11/19
							HAAS - 2	
							HAAS - 3	
							HAAS - 4	
100	HAAS 4 Axis - B4B	8 pcs	9/9/19	9/9/19	3.00	11.21	HAAS - 1 - B4B	
							HAAS - 2 - B4B	
							HAAS - 3 - B4B	SBL 19/11/19
							HAAS - 4 - B4B	
120	QC 1	8 pcs	9/9/19	9/9/19	0.00	0.00	QC 1 - 14	
							QC 1 - 35	
							QC 1 - 8	
							QC 1 - 9	
130	QC 8	8 pcs	9/9/19	9/9/19	0.00	0.00	QC 2 - 57	SBL 19/11/19
							QC 8 - 12	
							QC 8 - 14	PK 19/11/19
							QC 8 - 17	
							QC 8 - 20	
							QC 8 - 25	
							QC 8 - 3	
							QC 8 - 32	
							QC 8 - 33	
							QC 8 - 35	
							QC 8 - 39	
							QC 8 - 4	
							QC 8 - 44	
							QC 8 - 45	
							QC 8 - 49	
							QC 8 - 58	
							QC 8 - 8	
							QC 8 - 9	
							QC 8 - 68	
							QC 8 - 67	



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Container No: S229618



Part: D5467-1

Job No: 198587

Serial No/Batch: S229618

Revision: A

Inspector:

Exp Date:

Instructions: Various STC's

Date: 11/06/19

Plex 7/31/19 7:53 AM Dart.lajeunesse.marie

					QC 8 - 1 (A)	
					QC 8 - 47	
					QC 8 - 40	
					QC 8 - 52	
					QC 8 - 23	
					QC 8 - 57	
					Handfinish - 1 - 1 - B4B	
					Handfinish - 1 - 2 - B4B	
					Handfinish - 1 - 3 - B4B	NOV 11 2019
					Handfinish - 1 - 4 - B4B	
140 Handfinish - 1-1 Chemical-B4B	8 pcs	9/9/19	0.00	2.41	Handfinish - 1 - 5 - B4B	
					Handfinish - 1 - 6 - B4B	
					Handfinish - 1 - 7 - B4B	
					Handfinish - 1 - 8 - B4B	
					Handfinish - 1 - 9 - B4B	
					Handfinish - 1 - 10 - B4B	
					Handfinish - 1 - 11 - B4B	
					Handfinish - 1 - 12 - B4B	
					Handfinish - 1 - 13 - B4B	
					Handfinish - 1 - 14 - B4B	
					Handfinish - 1 - 15 - B4B	
					Handfinish - 1 - 16 - B4B	
					Handfinish - 1 - 17 - B4B	
					Handfinish - 1 - 18 - B4B	
150 Spray Paint - 2 - B4B	8 pcs	9/9/19	0.00	0.19	Handfinish - 1 - 19 - B4B	
					Handfinish - 1 - 20 - B4B	
					Handfinish - 1 - 21 - B4B	
					Handfinish - 1 - 22 - B4B	
160 QC 14	8 pcs	9/9/19	0.00	0.00	Spray Paint - 1 - B4B	
					Spray Paint - 2 - B4B	RD 19-11-11
					Spray Paint - 3 - B4B	
					Spray Paint - 4 - B4B	
					QC 14 - 15	
					QC 14 - 2	
					QC 14 - 34	
					QC 14 - 41	
					QC 14 - 51	
					QC 14 - 58	
					QC 14 - 59	
					QC 14 - 9	
					QC 14 - 68	DAS NOV 12 2019 68
					QC 14 - 40	9-89
170 Packaging 3-1 - Stock - B4B	8 pcs	9/9/19	0.00	0.00	QC 14 - 19	
					QC 14 - 43	
					QC 14 - 24	
					QC 14 - 61	
					QC 14 - 81	
					Packaging 3 - 1 - B4B	

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NOV 13 2019

Packaging 3 - 2 - B4B

Packaging 3 - 3 - B4B ✓

ST399

Packaging 3 - 4 - B4B

Packaging 3 - 5 - B4B

Packaging 3 - 6 - B4B

Packaging 3 - 7 - B4B

Packaging 3 - 8 - B4B

Packaging 3 - 9 - B4B

Packaging 3 - 10 - B4B

Packaging 3 - 11 - B4B

Packaging 3 - 12 - B4B

Packaging 3 - 13 - B4B

Packaging 3 - 14 - B4B

Packaging 3 - 15 - B4B

Packaging 3 - 16 - B4B

Packaging 3 - 17 - B4B

Packaging 3 - 18 - B4B

Packaging 3 - 19 - B4B

Packaging 3 - 20 - B4B

Packaging 3 - 21 - B4B

Packaging 3 - 22 - B4B

Packaging 3 - 23 - B4B

Packaging 3 - 24 - B4B

Packaging 3 - 25 - B4B

Packaging 3 - 26 - B4B

Packaging 3 - 27 - B4B

Packaging 3 - 28 - B4B

Packaging 3 - 29 - B4B

Packaging 3 - 30 - B4B

Packaging 3 - 31 - B4B

Packaging 3 - 32 - B4B

Packaging 3 - 33 - B4B

Packaging 3 - 34 - B4B

Packaging 3 - 35 - B4B

Packaging 3 - 36 - B4B

180 QC 21 - SA

8 ✓

pcs

9/9/19

0.00 0.00

QC 21 - SA - 21 ✓

ST399

QC 21 - SA - 70

QC 21 - SA - 53

DAS
21

NOV 13 2019

Part Op 100 - (HAAS CNC Vertical Machine) Program Batch No. 5229067 Double check by: U.M. 1-Machine Step No 1 per
 Descriptions: Folio FB550 and inspect per attached Dimension Sheets 2-Machine Step No 2 per Folio FB550 and inspect per attached
 Dimension Sheets 3-Machine Step No 3 per Folio FB550 and inspect

120 - (QC1- Inspection performed by CMM) Inspect on CMM as per folio CMMA022. DWG REV: N/A CMM PROG.
 REV: N/A

130 - (QC8- Inspect parts - second check)

140 - (Chemical Conversion Coat per QSI005 4.1)

150 - (Spray Paint / NDT Room) ***MASK HOLES PRIOR TO PRIME AND PAINT AS PER DWG NOTE 9*** 1-PRIME AS
 PER DWG AND QSI005 4.2.1.3.3 PRIMER BATCH: 5200299 2-PAINT AS PER DWG AND QSI005 4.2.2.4

PAINT BATCH: 5217125

160 - (QC14- Inspect Spray Paint)

170 - (Identify as per dwg & Stock Location: _____)

180 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6101-007	Saddle Billet	8 pcs (1 ea)	100-HAAS 4 Axis - B4B	<u>5204067</u>

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-HAAS 4 Axis - B4B	D6101-007	8	21	0

Part Specifications
Specifications could not be found.

Plex 7/31/19 7:53 AM Dart.lajeunesse.marie

DART AEROSPACE LTD		Work Order:	198581
Description: Saddle, Fwd Outboard		Part Number:	D5467-1
Inspection Dwg: D5467 Rev. A		Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443		.438	.438	.438	.438		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		7.998	7.998	7.998	7.998		
F	0.490	0.510		.501	.501	.501	.501		
G	0.257	0.262		.257	.257	.258	.258		
H	0.375	0.380		.375	.375	.375	.375		
I	0.490	0.510		.499	.499	.500	.499		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.5625	.567	.568	.567		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.490	1.500		1.495	1.495	1.495	1.495		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.874	3.874	3.874	3.874		
P	0.115	0.135		.135	.132	.135	.132		
Q	0.115	0.135		.1245	.125	.125	.125		
R	0.240	0.260		.2505	.250	.250	.250		
S	0.115	0.135		.132	.130	.130	.130		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		.243	.239	.239	.239		
W	0.115	0.135		.128	.128	.126	.127		
X	0.352	0.372		.360	.366	.367	.367		
Y	0.470	0.530		.500	.500	.500	.500		
Z	0.615	0.635		.624	.624	.625	.625		
AA	0.053	0.073		.060	.063	.063	.063		
AB	0.240	0.260		.253	.250	.250	.250		
AC	1.375	1.395		1.385	1.385	1.385	1.385		
AD	0.115	0.135		.135	.135	.135	.132		
AE	0.240	0.280		.255	.260	.260	.260		
AF	0.240	0.260		.249	.255	.252	.252		
AG	2.000	2.020		2.000	2.000	2.000	2.000		
Accept/Reject									

Measured by:	VJK SBL
Date:	19/11/11

Audited by:	mk
Date:	19/11/11

Rev	Date	Change	Revised by	Approved
A	18.05.30	New Issue	MG	

DART AEROSPACE LTD		Work Order: 198587
Description: Saddle, Fwd Outboard		Part Number: D5467-1
Inspection Dwg: D5467 Rev. A		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				#5	26	37	48		
A	0.438	0.443		.438	.436	.438	.438		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		7.998	7.998	7.998	7.998		
F	0.490	0.510		.500	.500	.499	.499		
G	0.257	0.262		.258	.258	.258	.258		
H	0.375	0.380		.375	.375	.375	.375		
I	0.490	0.510		.499	.500	.500	.499		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.568	.568	.569	.568		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.490	1.500		1.495	1.495	1.495	1.495		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.874	3.874	3.874	3.874		
P	0.115	0.135		.132	.132	.131	.128		
Q	0.115	0.135		.125	.125	.124	.124		
R	0.240	0.260		.251	.251	.250	.250		
S	0.115	0.135		.130	.131	.130	.130		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		.238	.239	.238	.239		
W	0.115	0.135		.127	.126	.126	.125		
X	0.352	0.372		.367	.367	.368	.368		
Y	0.470	0.530		.500	.500	.500	.500		
Z	0.615	0.635		.625	.626	.624	.624		
AA	0.053	0.073		.063	.063	.063	.061		
AB	0.240	0.260		.250	.249	.248	.250		
AC	1.375	1.395		1.385	1.385	1.385	1.385		
AD	0.115	0.135		.130	.128	.128	.122		
AE	0.240	0.280		.260	.260	.260	.260		
AF	0.240	0.260		.252	.252	.252	.252		
AG	2.000	2.020		2.000	2.000	2.000	2.000		
Accept/Reject									

Measured by: SBL	Audited by: JKL
Date: 19/11/11	Date: 19/11/11

Rev	Date	Change	Revised by	Approved
A	18.05.30	New Issue	MG	